

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020043**Date Inspected:** 06-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng Wei			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, Edge Beam.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel Heat Straightening Edge Beams Identified as EB3006B & EB3006A. ZPMC QC Li Ming Yang showed Heat Straightening Report HSR # 8262 & 8261 respectively. The attached photographs provide additional detail.

Assembly, Bay 14, 12CE, Deck Panel Diaphragm.

FCAW welding of weld joint DP3030-001-241, 246, 251, 256, 85, 90, 95, 100; located on assembly, Bay 14, 12CE. Welders are identified as 044790; ZPMC Quality Control Inspector (QC) is identified as Li Lu Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Assembly, Bay 14, 10AW, PP85.5.

During Random Visual in process Inspection, this QA inspector observed fit-up X37-Stiffener at 10AW PP85.5. The attached photographs provide additional detail.

Assembly, Bay 14, 12BE, Corner Assembly CA3002, Edge plate to Deck plate.

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FCAW welding of weld joint CA3002-004; located on assembly, Bay 14, 12BE. Welder is identified as 066733, 055491; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, 12AW, Deck plate (DP3044A) to Deck plate (DP3043A).

SAW welding of weld joint SEG3004*-005; located on assembly, Bay 14, 12AW. Welder is identified as 204730; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12BW, Stiffener for Longitudinal diaphragm .

SMAW welding of weld joint SEG3005M-020, 061; located on assembly, Bay 14, 12BW. Welder is identified as 066038, 067764; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Assembly, Bay 14, 12AE, Stiffener for Corner Assembly Diaphragm.

FCAW welding of weld joint SEG3001P-188, 187; located on assembly, Bay 14, 12AE. Welder is identified as 055491; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-F.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed ZPMC personnel mounted Bottom panel on the temporary support structure (jig).

This QA Inspector carried out NDE on following

Bay 19, Suspender Bracket.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005479). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- SB013-064-002, 003, 021, 022, 027, 028.
- SB013-064-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060.
- SB013-064-069, 070.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer